

**ABSTRACT****METHOD OF CALIBRATING A SCANNING SYSTEM**

5 A method of measuring an object on a coordinate  
positioning apparatus. A first object is placed on a  
coordinate positioning apparatus and measured with a  
workpiece contacting probe to create measurement data.  
The measurement data is collected at multiple stylus  
10 deflections or probe forces. For a plurality of points  
on the surface of the first object, the measurement  
data is extrapolated to that corresponding to zero  
stylus deflection or zero probe force. An error  
function or map is created from the measurement data  
15 and the extrapolated data. Subsequent objects are then  
measured using a known stylus deflection or known probe  
force and the error function or map is used to apply an  
error correction to these measurements.

20 Fig 1